

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028673**Date Inspected:** 17-Oct-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA observed the following welders working in OBG 12E at various locations:

ABF welder Xiao Hua Luo #1291 was observed performing weld repairs on weld 12E PP116.5-E2.3-BW1 at y=385mm. The dimensions of the excavations were noted as 60L/25W/8D on face A and 70L/25W/8D on face B. The welder was observed utilizing Welding Procedure Specification (WPS)

ABF-WPS-D15-1000-Repair-Revision 2 for Shielded Metal Arc Welding (SMAW). The welder was observed preheating the welds prior to Carbon Arc Gouging and welding. Other welding parameters as inspected by QC Inspector appeared to be in compliance with the WPS noted above. This repair is noted as an R1 and no RWR is required.

ABF welder Lin E Yun #9344 was observed performing weld repairs on weld 12E PP111.5-E2.3-PS3 at y=0mm. The dimensions of the excavation was noted as 95L/40W/11D. The welder was observed utilizing ABF-WPS-D15-1000-Repair-Revision 2 for SMAW. The welder was observed preheating the welds prior to Carbon Arc Gouging and welding. Other welding parameters as inspected by QC Inspector appeared to be in compliance with the WPS noted above. This repair is noted as an R1 and no RWR is required.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

ABF welder James Zhen #6001 was observed performing weld repairs on weld 12E PP117-E2.3-BW4 at y=50mm. The dimensions of the excavations were noted as 70L/25W/9D and y=190mm; 80L/35W/9D. The welder was observed utilizing ABF-WPS-D15-1000-Repair-Revision 2 for SMAW. The welder was observed preheating the welds prior to Carbon Arc Gouging and welding. Other welding parameters as inspected by QC Inspector appeared to be in compliance with the WPS noted above. This repair is noted as an R1 and no RWR is required.

This QA Inspector performed Magnetic Particle (MT) testing on the welds listed below. This QA Inspector performed MT testing utilizing the yoke method in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6.26.2.1. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

12E PP115.5-BW3/PS3, 12E PP113.5-E2.1-BW1/BW2/FP1/PS1/PS2/PS3,
12E PP116-PS3/FP1

This QA Inspector performed an Ultrasonic (UT) inspection on approximately 10% of the welds listed below. This QA Inspector noted no indications at the time of testing. These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. This QA generated a TL-6027 UT report on this date. The testing was performed in accordance with AWS.D1.5-2002 Section 6, table 6.3.

12E PP112.5-E2.1-BW1/BW2/PS3/FP1
12E PP114.5-E2.1-BW1/BW3/PS1/PS3/FP1
12E PP115.5-E2.1-BW3/PS3
12E PP116-FP1/PS3

This QA observed QC Inspector William Sherwood and Salvador Merino performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. Also noted were QC Inspectors John Pagliero and Harry Scharein performing various Non-Destructive Testing (NDT) on completed weld repairs as they became available for testing. Non-Destructive Testing methods utilized by the QC Inspectors were Visual Testing (VT), Magnetic Particle Testing (MPT) and Ultrasonic Testing Shear Wave (UTSW). QC Inspectors were observed performing inspection per applicable code and or contract criteria.

Unless otherwise noted, all work observed on this date appeared to generally comply with the contract documents.

Summary of Conversations:

Conversations relevant to work performed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas 916-764-6027 , who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
